

Work Order ID 58015

April 21, 2010 12:58:11 PM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 21/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B 10-4-28

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

sf 10/5/06
aml 10/5/05

(19)

19

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

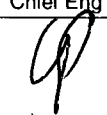
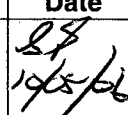
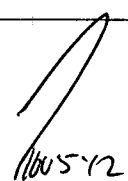
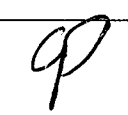
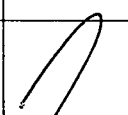
Quality Control

aml 10/5/05

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2432 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 10/05/12
 Resolution: Accepted Disposition: use as is QA: N/C Closed: _____ Date: 10/05/12

NCR: 58015		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/06	130	Parts lift when machining too many thickness are under tolerance. RC. Two way tape was done	 10.05.06 AS 1042	0.625 DIM AS LOW AS 0.580, 0.250 DIM AS LOW AS 0.220. NOT HIGH STRESS AREA ACCEPTABLE	 10/05/06	 10/05/12	 10.05.06 AS 1042	 10/05/12

NOTE: Date & initial all entries

Work Order ID 58015

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Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 21/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

H. A 10/05/09

19 0

151

Identify as per dwg & Stock Location: 445

0.00



Packaging

Memo

0.00

Packaging

10-5-11 590

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/12
MF
10-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58015



Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 21/04/2010

Required Date: 28/04/2010

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	212.0000	74.0000 		18 10-4-28	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

212

112186

50

113903

162

113903

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58015
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.056 x 45°	✓			
B	5.500	+/-0.030	5.505	✓			
C	0.200	+/-0.030	.200	✓			
D	0.25 x 45°	+/-0.030	0.247 x 45°	✓			
E	R0.250	+/-0.030	R.250	✓			
F	0.250	+/-0.010	.254	✓			
G	0.625	+/-0.030	.628	✓			
H	0.375	+/-0.010	.385	✓			
I	0.950	+0.030/0.010	.964	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.125	✓			
L	3.28	+/-0.030	3.300	✓			
M	Ø0.260	+0.005/-0.000	Ø.260	✓			
N	Ø0.93	+/-0.030	Ø.928	✓			
O	0.30	+0.030/-0.000	.325	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.380	✓			

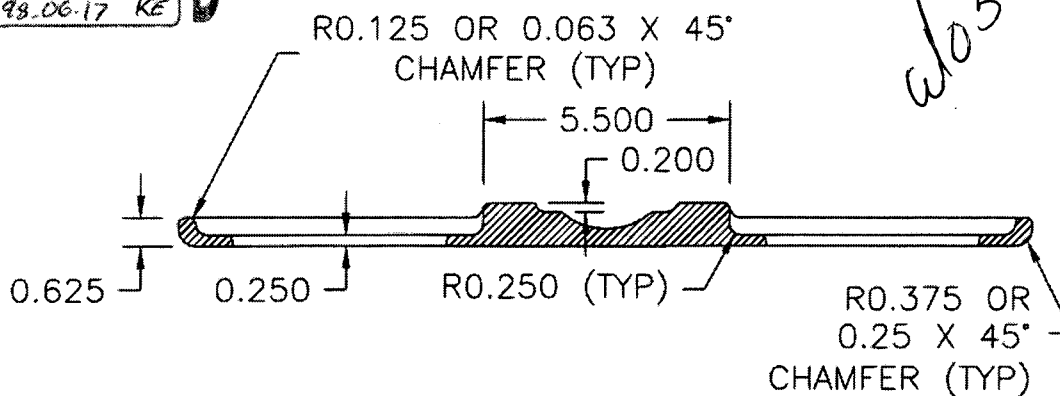
Measured by:	<i>[Signature]</i>	Audited by:	M. A	Prototype Approval:	N/A
Date:	10/05/05	Date:	10/05/09	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

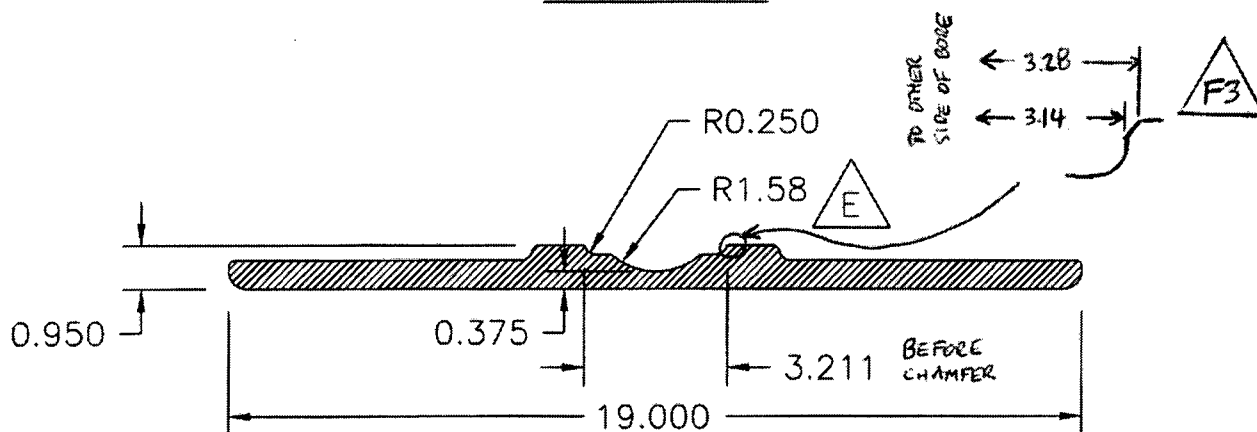


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:4	

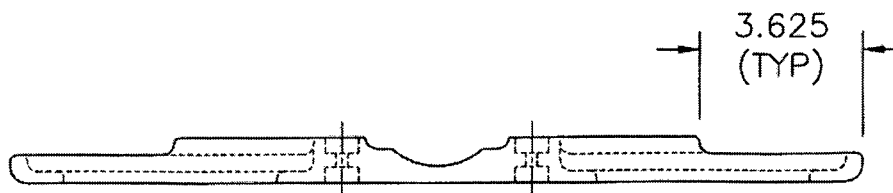
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C